

Sprint
SP 07/12/20

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: ACCESS PANEL ASSEMBLY		
Job Number	: 35050 -2		Part Number	: D3245042		
Estimate Number	: 13009		Drawing Number	: D3245 REV B		
P.O. Number	: N/A		Project Number	: N/A		
This Issue	: 11/13/2007 S.O. No. : N/A		Drawing Revision	: B		
Prsht Rev.	: NC		Material	: N/A		
First Issue	: N/A		Due Date	: 11/28/2007 Qty: 6 Um: Each		
Previous Run	: 34552					
Written By	:					
Checked & Approved By	:					
Comment	: Est Rev: A New Issue 07-09-11 JLM Verified By:EC Est Rev:b ECN 1052 07-10-31 DD verified by:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit			
2.0	D32452	Panel	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Panel Batch: B 354-31			
3.0	D32455	Angle Plate	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) 33460+3 Angle Plate Batch: B 35047 x6 B 35667 x2 18 07/12/19 (12)			
4.0	235018C3Y	RIGID RECEPTACLE	
Comment: Qty.: 8.0000 Each(s)/Unit Total : 48.0000 Each(s) RIGID RECEPTACLE Batch: M 106037 18 07/12/19 (12)			
5.0	MS20427M33	Rivet	
Comment: Qty.: 16.0000 Each(s)/Unit Total : 96.0000 Each(s) Rivet Batch: M 101840 x21 M 105728 x78 18 07/12/14 (12)			
<p><i>Double check</i></p> <p>M 105740 x90 ✓ All Same Part Batch</p>			

er: Tuesday, 11/13/2007 1:24:11 PM
Customer: CU-DAR001 Dart Helicopters Services

Process Sheet

Drawing Name: ACCESS PANEL ASSEMBLY

Job Number: 35650

Part Number: D3245042

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

MS20615M33 3183

Rivet

All same batch



Comment: Qty: 9.0000 Each(s)/Unit Total: 54.0000 Each(s)

Rivet

M106.77



AS 07/12/19

(6)

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Rivets and Nut Plates and Dwg D3245-5 angle as per Dwg D3245

mf 07-12-20

(6)

8.0 QC5

INSPECT WORK TO CURRENT STEP



5 07/12/20

(6)

Comment: INSPECT WORK TO CURRENT STEP

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart P# and B# using fine point permanent ink marker and Stock

Location: 8183

AS 07/12/20

(6)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



07/12/20

(6)

Comment: FINAL INSPECTION/W/O RELEASE

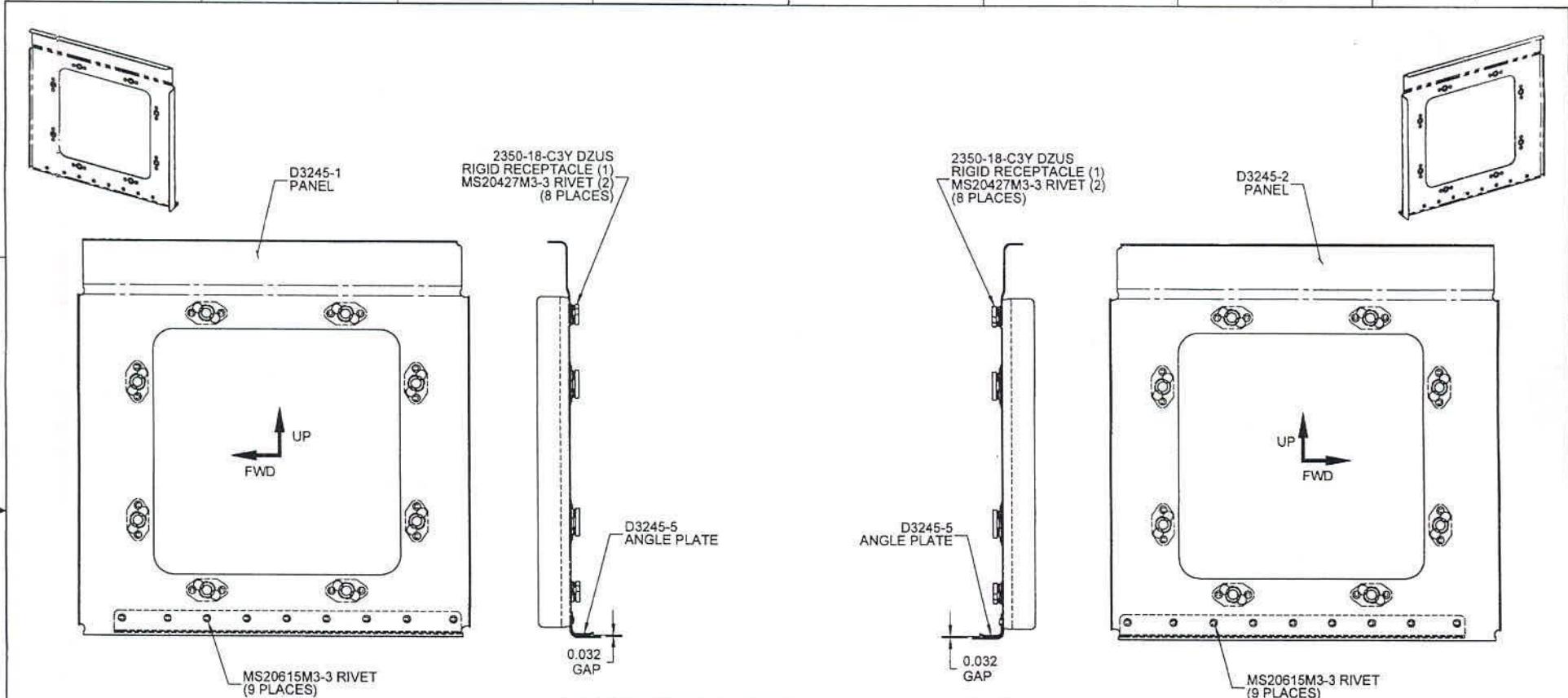
Job Completion



mf 07/12/21

U

8 7 6 5 4 3 2 1



RELEASED
07.10.02

NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) ASSEMBLE IN ACCORDANCE WITH DART QSI 002
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3245-XX" AND B/N "BXXXX" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 0.63 lbs

QTY -041	QTY -042	P/N	DESCRIPTION
X	X	D3245-041	ACCESS PANEL ASSEMBLY, LH
		D3245-042	ACCESS PANEL ASSEMBLY, RH
1	1	D3245-1	PANEL
1	1	D3245-2	PANEL
1	1	D3245-5	ANGLE PLATE
8	8	2350-18-C3Y	DZUS RIGID RECEPTACLE
16	16	MS20427M3-3	RIVET
9	9	MS20615M3-3	RIVET

B	REMOVE .00204 HOLES FROM D3245-1-1F. REMOVE MS21050L3K NUTPLATES & DURABLE BLACK GASKETS FROM D3245-041/042. HOLES AND ITEMS ARE NOW PART OF INSTALLATION. ASSIGN PINS TO GASKETS & REFORMAT DRAWING	MB	07.10.02
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	<u>1F</u>	DART AEROSPACE LTD	
DRAWN	<u>1A</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>PH</u>	DRAWING NO.	REV. B
MFG. APPR.	<u>DA</u>	D3245	SHEET 1 OF 7
APPROVED	<u>10</u>	TITLE	SCALE
DE APPR.	<u>10</u>	ACCESS PANEL ASSEMBLY	12.5
DATE	07.10.02	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

WORK ORDER NO. 3245-02
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STRICT TO AMENDMENT
WITHDRAWN
C. S. R.
S. C. R.

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